



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

004969

648.4704
Job Sheet 180403



Part No: 648.4704

Job Qty: 1 ea

Part Name: C45 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/5/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM & OOPM-C45 Rev 4 (648.4704) IPP Rev A 18.04.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/7/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	1 pcs		8/7/18	0.00	1.00	Small Fab-3		
120	QC	1 pcs		8/7/18	0.00	0.00	QC4		
121	DC	1 pcs		8/7/18	0.00	0.00	DC		
130	Packaging	1 pcs		8/7/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		8/7/18	0.00	0.00	QC21		

Part Op 100 - Pick bag and tag

Descriptions: 121 - Supply owner's & overhaul procedures manual

M.A sold

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1149F0463P	Washer	3 Ea (3 ea)	90-Start up Operation	5078780
NAS1149F0563P	Washer	8 Ea (8 ea)	90-Start up Operation	5067901
188-FPSS-1/4-20-3/8	see P/N 188-FPSS-1/4-20-3/8	2 Ea (2 ea)	100-Small Fab	5075264
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	100-Small Fab	5078378
600.1309-A	Label	1 Ea (1 ea)	100-Small Fab	
600.1312	Caution Sticker	1 Ea (1 ea)	100-Small Fab	5072105
AN4-23A	Bolt	2 Ea (2 ea)	100-Small Fab	FD23434-40
AN5-21A	Bolt	4 Ea (4 ea)	100-Small Fab	5093603
C2-14-2	Label Rivets	2 Ea (2 ea)	100-Small Fab	5040661
C45-10-1	Spring Pin	1 Ea (1 ea)	100-Small Fab	5040658
C45-10-2	Lock Spring	1 Ea (1 ea)	100-Small Fab	5099970
C45-11-2	Locating Pin	2 Ea (2 ea)	100-Small Fab	5054326
C45-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5091795
C45-12-6	Retaining Ring	2 Ea (2 ea)	100-Small Fab	5054986
C45-13-1	Keeper Bushing	2 Ea (2 ea)	100-Small Fab	5101278
C45-13-2	Spacer	2 Ea (2 ea)	100-Small Fab	5097746
C45-13-5	Keeper Spring	1 Ea (1 ea)	100-Small Fab	5029308
C45-3-1	Radial Bearing	2 Ea (2 ea)	100-Small Fab	5091767
C45-3-12	DU Bearing	1 Ea (1 ea)	100-Small Fab	5091768
C45-3-2-1	Snap Ring	2 Ea (2 ea)	100-Small Fab	5097898
C45-3-4-1	Retaining Ring	4 Ea (4 ea)	100-Small Fab	5068056
C45-3-5	Spacer	2 Ea (2 ea)	100-Small Fab	5097745
C45-3-8A	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab	5076197

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																				
Date : _____		MRB (QSI042) Approval _____																																																																																																																				
Description _____		Completed By _____																																																																																																																				
Lead hand / Supervisor Approval Verification _____		QC / QA Coordinator Approval _____																																																																																																																				
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Environment</td><td style="width:5%;">☐</td><td style="width:15%;">No Re-verify</td><td style="width:5%;">☐</td><td style="width:15%;"></td><td style="width:5%;"></td><td style="width:15%;"></td><td style="width:5%;"></td><td style="width:15%;"></td><td style="width:5%;"></td></tr> <tr> <td>Design</td><td>☐</td><td>Operator</td><td>☐</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td></tr> <tr> <td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td></tr> <tr> <td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td></tr> <tr> <td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td></tr> <tr> <td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td></tr> <tr> <td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td></tr> <tr> <td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td><td colspan="6" rowspan="2">OTHER : _____</td></tr> <tr> <td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verify	☐							Design	☐	Operator	☐							Doc/Data	☐	Offset/Setup	☐							Equip/Tooling	☐	Supplier	☐							Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						Misidentified	☐	Past Due	☐	Date: 08/13/18 Part: 648.4704 Job No: 180403 Serial No/Batch: S101622 Revision: 4 Inspected: Exp Del: Instructions: Date: 08/13/18		
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C45-3-8B	Actuator Shaft Bushing	1 Ea (1 ea)	100-Small Fab
C45-3-9	Lever Spring	1 pcs (1 ea)	100-Small Fab
C45-4-1	Trunnion Bushing	2 Ea (2 ea)	100-Small Fab
C45-5-1	Lever Stop Pin	1 Ea (1 ea)	100-Small Fab
C45-7-1	LOADBEAM BUMPER	1 Ea (1 ea)	100-Small Fab
C45-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab
C45-8-4	Solenoid Cover Gasket	1 Ea (1 ea)	100-Small Fab
MS21044N5	Nut	4 Ea (4 ea)	100-Small Fab
MS27039-4-08	Screw	1 Ea (1 ea)	100-Small Fab

5078801
 5089520
~~5089520~~ 5078803
 5040657
 5029332
 5095587
 5091820
 5097089
 5097087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1149F0463P	3	747	0
	NAS1149F0563P	8	626	0
100-Small Fab	188-FPSS-1/4 20-3/8	2	0	0
	188-FSCS-1032-5/8	4	377	0
	600.1309-A	1	0	0
	600.1312	1	22	0
	AN4-23A	2	588	0
	AN5-21A	4	73	0
	C2-14-2	2	206	0
	C45-10-1	1	91	0
	C45-10-2	1	11	0
	C45-11-2	2	78	0
	C45-12-1	2	16	0
	C45-12-6	2	84	0
	C45-13-1	2	13	0
	C45-13-2	2	82	0
	C45-13-5	1	95	0
	C45-3-1	2	18	0
	C45-3-12	1	12	0
	C45-3-2-1	2	54	0
	C45-3-4-1	4	156	0
	C45-3-5	2	78	0
	C45-3-8A	1	57	0
	C45-3-8B	1	38	0
	C45-3-9	1	0	0
	C45-4-1	2	48	0
	C45-5-1	1	41	0
	C45-7-1	1	0	0
	C45-7-2	2	12	0
	C45-8-4	1	0	0
	MS21044N5	4	139	0
	MS27039-4-08	1	78	0

Part Specifications

Specifications could not be found.

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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